

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020548**Date Inspected:** 01-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Corporation, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr.Tian lie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Steel Barrier**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Delbert Humphrey was present during the times noted above for observations relative to the work being performed at ZPMC.

OBG Bay # 1 Steel Barrier

WELDING

This QA Inspector observed the following work in progress:

FCAW welding of weld joint E2-SB29-A-001-002. Located on Steel Barrier, identified as E2-SB29-A-001. Welder is identified as 215082, ZPMC Quality Control (QC) is identified as Mr.Tian lie. The welding variables recorded by QC appeared to comply with WPS-B-P-2231-ESAB.

SMAW welding of weld joint E2-SB1-012-001-004. Located on Steel Barrier, identified as E2-SB1-012-001. Welder is identified as 214244, ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-P-2112.

OBG Bay # 16

WELDING

This QA Inspector observed the following work in progress:

SMAW welding of weld joint E2-SB12-001-002. Located on Steel Barrier, identified as E2-SB12-001. Welder is identified as 215082, ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables

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## WELDING INSPECTION REPORT

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recorded by QC appeared to comply with WPS-B-P-2113.

SMAW welding of weld joint W5-SB11-040-051. Located on Steel Barrier identified as W5-SB11-040. Welder is identified as 215082, ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-P-2113.

SMAW welding of weld joint 20TR2-051-009. Located on Traveler Rails identified as 20TR2-051. Welder is identified as 045268, ZPMC Quality Control (QC) is identified as Mr. Yin Chun fang. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)Repair 1 and Welding Repair Report # B-CWR1568.

OBG Bay #28

### WELDING

This QA Inspector observed the following work in progress:

FCAW welding of weld joint SA3321B-020-004, located on Splice Plate, identified as SA3321B-020. Welder is identified as 059378, ZPMC Quality Control (QC) is identified as Mr. Liu dao feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

FCAW welding of weld joint SA3321B-028-002, located on Splice Plate, identified as SA3321B-028. Welder is identified as 059378, ZPMC Quality Control (QC) is identified as Mr. Liu dao feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

FCAW welding of weld joint SA3321B-011-003, located on Splice Plate, identified as SA3321B-028. Welder is identified as 205805, ZPMC Quality Control (QC) is identified as Mr. Liu dao feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

OBG Bay # 28

### NDT

The following NDT performed ZPMC NDT notification 07991:

This QA inspector performed UT testing on 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector Delbert Humphrey generated an UT report for this date. Time of inspection was 16:15 hours. The members are identified as follows OBG, Steel Barrier, The weld designations reviewed are as follow: W5-SB8-001, 002, 003, E5-SB12-001, 002, 003.

OBG Bay # 28

### NDT

The following NDT performed ZPMC NDT notification 08010:

This QA inspector performed MT testing on 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector Delbert Humphrey generated an MT report for this date. Time of inspection was 14:15 hours. The members are identified as follows OBG, Steel Barrier, The weld designations reviewed are as follow: E5-SB8-001, 002, 003, E5-SB12-001, 002, 003.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable

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contract documents.

### Summary of Conversations:

No relevant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Humphrey, Delbert
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Hall, Steven
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QA Reviewer
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